Work Order ID 65294

January 11, 201	11 9:17:17 2	4 <i>M</i>			ija 1:818 18:11 8181 18 <b>41</b>							2 480
Item ID: Revision ID:	D3413-1			Accept				S	Setup S	Start Stop		
Item Name: Start Date: Required Date: Reference:	Ring 1/11/11 : 1/21/11	Start Qty: 10.00 Req'd Qty: 10.00			Cust Item l Customer:	ID:						
Approvals:		Plan: MF	Date: _// < _O/ ~ // Date:			ate:		F		Start Stop		
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rejec Qty		Reject Number	Insp. Stamp
Draw Nbr	Re	evision Nbr										
D3413	Re	ev A										
Waterjet FLOW CNC Water 304 .750		FLOW WATER JET  Memo  1-Cut as per  Dwg Rev:  Prog Rev:  2-Deburr if		0.00				-B11-1	-11		l	
QC Quality Control		QC2- Inspect parts off m  Memo	achine FAI/FAIB -	0.00				H31	<u> -   -  </u>	(		- <del></del> <del>-</del>
120		OC8- Inspect parts - seco	and check	0.00								

Quality Control

Sulodu

Memo

Dart	Aero	spac	e Ltd
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W/O:			W	ORK ORDER CHANG	iES				., .
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
								··· ,	
Part No	-	PAR #:	Fault Ca	tegory:	NCR: Yes	No <b>DQ</b>	A:	Date: _	
	R	esolution:	Disposit	ion:	_ QA: N/C C	losed:		Date: _	11 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1
NCR:			WORK OR	DER NON-CONFORM	ANCE (NC	R)			
DATE	STEP	Description of NC			tion B Sign		cation		Approval
	J	Section A	Initial Chief Eng	Action Description Chief Eng	Date		tion C	Chief Eng	QC Inspector
		4.							
1									

### Work Order ID 65294



Page 2

January 11, 2011 9:17:17 AM

Item ID:

D3413-1

Ring

Item Name: **Start Date:** 

**Revision ID:** 

1/11/11

QC:

**Start Qty: 10.00** 

Accept

Setup Start

Stop



Required Date: 1/21/11

Req'd Oty: 10.00

**Cust Item ID: Customer:** 

Tool ID

Reference:

**Approvals:** 

Process Plan:

Date:

**Tooling:** Date:

SPC (Y/N):

Date: Date:

Tool # Plan

Code

Run

Accept

Qty

Start

Stop

Reject

Reject

Qty



Number Stamp

Insp.

Sequence ID/

**Work Center ID** 

130

Small Fab Small Fab

Operation Description

Small Fab

Set Up/ **Run Hours** 

0.00

0.00

1- Deburr and drill hole if required as per dwg D3413 & QSI018 4.1

140

QC

**Quality Control** 

QC5- Inspect part completeness to step on W/O

Memo

Memo

150

Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

10 Bl 11-01-17.

									c .
W/O:		11.200	WO	RK ORDER CHANGE	S				
DATE	STEP	PRO	OCEDURE CHAN	GE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Categ	ory:	NCR: Yes	No <b>DQ</b>	A:	Date:	
	R	esolution:	Disposition	:	QA: N/C CI	osed:		Date: _	
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCF	R)		,	
DATE	OTED	Description of NC		Corrective Action Section		Verifi	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	k Sect	ion C	Chief Eng	QC Inspector
	1								
	1								

### Work Order ID 65294

January 11, 2011 9:17:18 AM



Page 3

Item ID:

D3413-1

Accept



Setup Start

Stop



**Revision ID:** 

**Start Date:** 

**Item Name:** 

Required Date: 1/21/11

Ring

1/11/11 **Start Qty: 10.00** 

QC:

Req'd Qty: 10.00



Date:\_\_\_\_\_

**Cust Item ID:** 

**Customer:** 

Reference:

**Approvals:** 

Date:

**Tooling:** 

SPC (Y/N):

Date: Date:

Tool # Plan

Run

Start

Reject

Qty

Stop

Reject

Number

Insp.

Stamp

Sequence ID/ **Work Center ID** 

160

Quality Control

Operation Description

QC3- Inspect Part Finish

Memo

Set Up/ **Run Hours** 

11/00/17

Tool ID

Code **Qty** 

Accept

170

Packaging

Packaging

Identify as per dwg & Stock Location: 473

Memo

0.00

0.00

0.00

180

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

# Dart Aerospace Ltd W/O: WORK ORDER CHANGES DATE STEP PROCEDURE CHANGE By Date Qty Approval Chief Eng / Prod Mgr QC Inspector Approval QC Inspector

Part No:		PAR #:	Fault Category:		NCR: Yes No	DQA:	Date:	
	Resolution:		Disposition:	- In the same	QA: N/C Closed	ļ:	Date:	

NCR:			WORK ORDE	ER NON-CONFORMANC	E (NCR)			
	T	Description of NC		Corrective Action Section B		Verification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC inspector
							·	
						,		
				1-3 140				

## **Picklist Print**

January 11, 2011 9:17:10 AM

Work Order ID: 65294

Parent Item: D3413-1

Parent Item Name: Ring

**Start Date: 1/11/11** 

Required Date: 1/21/11

**Start Qty: 10.00** 

Required Oty: 10.00

Comments:

IPP Rev:A□05.09.13□New issue□KJ/JLM
IPP Rev:B Now on Waterjet 07-05-28 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.250X4.000		Purchased	No			100	f	8.0000	0.25	2.631579	)		
										:40			

304 BAR .250 x 4.00

 Location
 Loc Qty
 Loc Code

 MAT
 8

 115953
 8

115953

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W/O:		······································	WO	RK ORDER CHANG	ES				4
DATE	STEP	PRO	OCEDURE CHAI	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	):	PAR #:	Fault Cated	iorv:	NCR: Yes	No DQA	\: \:	Date:	<u> </u>
		solution:							
NCR:		,	WORK ORDI	R NON-CONFORMA	NCE (NC	₹)			
DATE	STEP	Description of NC		Corrective Action Section		Verific		Approval	Approval
DATE	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign of Date		on C	Chief Eng	QC Inspector
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DART AEROSPACE LTD	Work Order: 656	294
Description: Ring	Part Number: D3	413-1
Inspection Dwg: D3413 Rev: A	Page	1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.88	+/-0.030	3.875	7		V BOZ	
Ø2.00	+0.012/-0.001	<i>2</i> 0,C	*		V	
0.75	+/-0.030	.752	*		V	
Ø0.266	+0.006/-0.001	D 66	A		V	
0.250	+/-0.010	.760	<b>y</b>		V	

Measured by:	K	Audited by:	Prototype Approval:	N/A
Date:	11-1-11	Date: 11/01/y	Date:	N/A

Rev	Date	Change	Revised by Approved
Α	07.09.06	New Issue	KJ/JLM Z
_	-		70

W/O:		WORK ORDER CHANGES									
DATE STEP			PROCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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		PAR #:	Fault Category: N			NCR: Yes No DQA: Date:					
		esolution:					•				
NCR:				DER NON-CONFORMA							
DATE	STEP	Description of NC Section A	Corrective Action Se		on B	Verific	cation	Approval	Approval		
			Initial Chief Eng	Action Description Chief Eng	Sign of Date	🖁   Secti	Section C	Chief Eng	QC Inspector		
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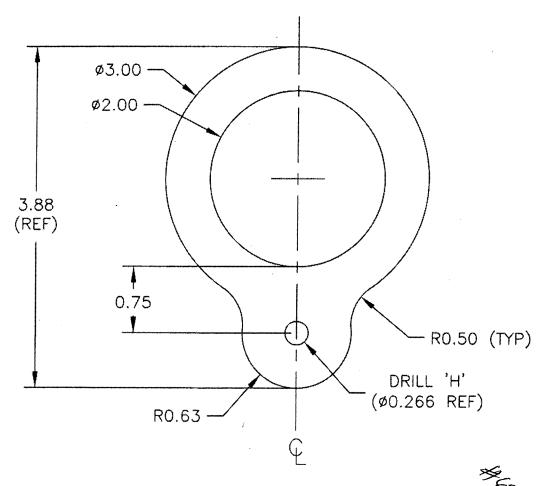
· NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE



	DESIG	CP	DRAWN BY	DART	AEROSPACE PORT HADLOCK,		INC.
	CHECK	H-	APPROVED	drawing no. D3413		SH	REV. A EET 1 OF 1
-	DATE			TITLE			SCALE
	05.0	3.16		RING			1:1
	Α		05.03.16	NEW ISSU	JΕ		





# D3413-1 RING

- 1) MATERIAL: AISI 304/316 SS PLATE, 0.250 THICK (REF DART SPEC. M304S3GA)
- 2) FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) DEBURR ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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W/O:	-		WC	RK ORDER CHANG	GES					
DATE STEP		PROCEDURE CHANGE				Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			:							
					1					
		PAR #:	Fault Cate	NCF	NCR: Yes No DQA: Date:					
		esolution:	Disposition:			_ QA: N/C Closed:			Date:	
NCR:			WORK ORDI	ER NON-CONFORM	MANCE	(NCR	)			
DATE	STEP	Description of NC Section A			ection B	Sign &	Verification		Approval	Approval
			Initial Chief Eng	Action Description Chief Eng		Date	Section	Section C	Chief Eng	QC Inspector
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